

Ship July 6th or sooner

Work Order ID 60000

June 22, 2010 2:33:17 PM



Page 1

Item ID: D205-541-141

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket, LH

Stop



Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date: Tooling:

Date:

Run Start



QC:

Date: SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description
--------------------------------	--------------------------

Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D205-541	J
----------	---

D4041	A
-------	---

100	0.00
-----	------



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPPD205-541-141

CHG001

Si 10/07/06

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble basket as per Dwg.

10/07/06. C

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Page 2

Item ID: D205-541-141

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
Description

120



QC

Quality Control

130



Packaging

Packaging

Memo

Set Up/
Run Hours

0.00

S10107106

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

0.00

40

0.00

P10107/23 ①

0.00

0.00

S10107166

40

0.00

140



QC

Quality Control

QC4- 100% Inspect kits for completeness

Memo

Work Order ID 60000

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Item ID: D205-541-141

Accept



Setup Start



Revision ID:

Item Name: Heli-Utility-Basket, LH

Stop



Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



Packaging

0.00

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD205-541-141

Location:

PPP Rev: REPORT

160



QC21- Final Inspection - Work Order Release

0.00

QC

Memo

0.00

Quality Control

Picklist Print

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Comments: IPP RevA: new issue DD 10.02.11 verified by:JLM
per ecn10-550 DD verified by:EC

IPP Rev:B as

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status	
D4042-041 		Manufactured		No		110	Each	0.0000	1	1		 B60003 (X)		 Ep 0/07/05
Short Basket Base Assembly, LH 		Manufactured		No		110	Each	0.0000	1	1		 B60002 (X)		 Ep 0/07/05
D4047-041 		Manufactured		No		110	Each	0.0000	1	1		 B59154 (X)		 Ep 0/07/05
Short Basket Lid Assembly 		Manufactured		No		110	Each	0.0000	1	1		 B60003 (X)		 Ep 0/07/05
D2530 		Manufactured		No		110	Each	0.0000	1	1		 B59154 (X)		 Ep 0/07/05
Handle Weldment 		Manufactured		No		110	Each	114.0000	2	2		 B60002 (X)		 Ep 0/07/05
D2535 		Manufactured		No		110	Each	114.0000	2	2		 B60003 (X)		 Ep 0/07/05
Spring 		Manufactured		No		110	Each	114.0000	2	2		 B60002 (X)		 Ep 0/07/05

Location	Loc Qty	Loc Code
----------	---------	----------

ST504	114	
56355	14	
58331	100	

56355

D4053-1 	Manufactured	No		110	Each	8.0000	1	1	 55278	 Ep 0/07/05
-------------	--------------	----	--	-----	------	--------	---	---	-----------	----------------

Location	Loc Qty	Loc Code
----------	---------	----------

ENG	8	
55278	8	

55278

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3969-3



Manufactured No

110 Each

11.0000



1

Spring (Basket Lid)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST	11	
56386	1	
58986	10	

D2537



Manufactured No

110 Each

15.0000



2

Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST504	15	
58429	15	

D3953-3



Manufactured No

110 Each

26.0000



2

Gas Spring Stud, Lid

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST102	26	
58894	6	
59437	20	

D3953-7



Manufactured No

110 Each

26.0000



2

Spring Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST103	26	
58893	6	
59438	20	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3953-9



Manufactured No

110 Each 20.0000



2 ✓

Gas Spring Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST101	20	
53642	2	
59147	18	

D3953-17



Manufactured No

110 Each 32.0000



2 ✓

Gas Spring Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST101	32	
57143	1	
58857	1	
59197	30	

D3953-19



Manufactured No

110 Each 15.0000



58857 18
59197 18
1 ✓

Gas Spring Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST101	1	
57607	1	
ST103	14	

D3953-21



Manufactured No

110 Each 26.0000



57607
1 ✓

Gas Spring Bracket

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ENG	5	
56407	5	
ST102	21	
57145	4	
59214	17	

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3917-3



Washer

Manufactured

No

110

Each

25.0000

6

6



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST096	25	
57144	1	
58892	24	

58892

5

AN310-4



NUT

Purchased

No

110

Each

15.0000

5



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST324	12	
114716	12	
ST349	3	
114341	3	

114716

4

AN3-14A



Bolt

Purchased

No

110

Each

80.0000

4



4

AN3-16A



Bolt

Purchased

No

110

Each

141.0000

2



2

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST352	141	
113845	21	
114523	20	
114752	100	

1113845

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN4-12



Purchased

No

110

Each

58.0000

3

3



Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	58	
114292	8	
114784	50	

114292

AN5-17A



Purchased

No

110

Each

143.0000

4

4



Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST339	143	
114330	97	
114784	46	

114330

MS21042L3



Purchased

No

110

Each

3,067.0000

6

6



Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST300	3067	
114523	567	
114718	500	
114784	2000	

114523

MS21042L5



Purchased

No

110

Each

677.0000

4

4



Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST139	500	
114813	500	
ST300	177	
114449	177	

114449

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

MS24665-231 10.07.06
P#2-051042

MS24665-231



cotter pin

Start Date: 6/22/10
Start Qty: 1.00

Required Date: 7/05/10

Required Qty: 1.00

Purchased No 110 Each 176.0000 5



NAS1149F036P Purchased No 110 Each 173.0000 4



Washer

113815

NAS1149F0463P Purchased No 110 Each 141.0000 5



Washer

113254

NAS1149F0563P Purchased No 110 Each 220.0000 4



Washer

114223

Location Loc Qty Loc Code

ST275 176 113815

176

110 Each 173.0000 4

113254

114382

100

110 Each 141.0000 5

114223

114348

100

110 Each 220.0000 4

108471

200

114576

200

200

200

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
10/07/06	110	MS24665-231 IS TOO BIG IN Ø AND TOO LONG. CHANGE TO MS24665-151 WHICH IS OF ADEQUATE SIZE AND LENGTH - PERMANENT CHG. M 17566	BB	10/07/06	3	10/07/06 BB WZL		

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

DSI 9302-011

Manufactured No

(130 Each 1.0000



B60039

60

Strut Modification

CHC7401

D2022-101

Manufactured No

58276

(130 Each 189.0000



Spacer

D2332-041

Manufactured No

Lid Prop Assembly 6.69" long

Location

Loc Qty

Loc Code

ST504

189

50746

89

52325

100

(130 Each 2.0000



D2464

Manufactured No

3/4 Seal

Location

Loc Qty

Loc Code

ST512

2

57645

2

(130 f 330.6534



3.4166

3.4166

3.42

60/01

(D2464-0410) cut (1) at 41.00"

Location

Loc Qty

Loc Code

ST402

330.6534

48173

330.6534

48173

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D3953-9

Manufactured

No

130

Each

20.0000

2
2



Gas Spring Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST101	20	
53642	2	
59147	18	

59147

11

D4048-041

Manufactured

No

130

Each

0.0000



Mounting Lug Assembly, LH

360001

D4048-5

Manufactured

No

130

Each

1.0000



Mounting Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST460	1	
58067	1	

58067

D4048-7

Manufactured

No

130

Each

1.0000



Mounting Lug

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST111	1	
58069	1	

58069

D4048-9

Manufactured

No

130

Each

32.0000



Bushing

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST111	32	
58071	32	

58071

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

D4049-041



Mounting Lug Assembly, LH

Manufactured

No

130

Each

1.0000



1

D4049-5



Mounting Lug, LH

Manufactured

No

58072

130

Each

3.0000



58072

1

D4050-1



Strut

Manufactured

No

58081

130

Each

1.0000



58081

1

D4050-3



Strut

Manufactured

No

56409

130

Each

1.0000



56409

1

D4050-5



Strut

Manufactured

No

ST254

46451

130

Each

1.0000



56451

1

ST267

58083

1

1

1.0000



58083

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

6 D4051-041



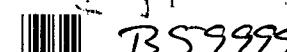
Manufactured

No

130

Each

0.0000



11

Rappel Deflector Assembly, LH

5 D4052-1



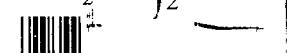
Manufactured

No

130

Each

8.0000



Eye Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST110	8	
-------	---	--

56622	8	
-------	---	--

	Each	
--	------	--

	813.0000	
--	----------	--

56622

10 10

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST350	813	
-------	-----	--

105057	813	
--------	-----	--

	Each	
--	------	--

	133.0000	
--	----------	--

100007

5 AN3-5A



Bolt

Purchased

No

130

Each

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST350	813	
-------	-----	--

105057	813	
--------	-----	--

	Each	
--	------	--

	133.0000	
--	----------	--

100007

6 AN3-7A



Bolt

Purchased

No

130

Each

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	133	
-------	-----	--

113539	14	
--------	----	--

114227	19	
--------	----	--

114784	100	
--------	-----	--

m114227

5 AN3-11A



Bolt

Purchased

No

130

Each

ST351	144	
-------	-----	--

110865	144	
--------	-----	--

144

144

m114227

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST351	144	
-------	-----	--

110865	144	
--------	-----	--

m114227

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W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

AN4-6A



Bolt

Purchased

No

130

Each

1,121.000

5

15



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	1121	
112933	96	
113149	522	
114523	2	
114615	1	
114941	500	

1113149

AN4-7A



Bolt

Purchased

No

130

Each

194.0000



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	194	
113226	194	

1113236

AN4-12A



Bolt

Purchased

No

130

Each

226.0000



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	226	
112314	226	

1112314

AN4-14A



Bolt

Purchased

No

130

Each

312.0000



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST357	296	
114752	296	
ST358	16	
113359	16	

1114752

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 22, 2010 2:33:06 PM

Page 12 1/4

Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

AN4-16A

Purchased

No

130

Each

60.0000



1

[Signature]

Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST358

60

114523

60

m114523

AN960-10

NAS1149F0363P Purchased

No

130

Each

8,012.000



5

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST348

8012

19356

200

5519

7812

5519

11 m113254

AN960-416

NAS1149F0463P Purchased

No

130

Each

0.0000



11

Washer

AN960JD10L

NAS1149D0332J Purchased

No

130

Each

3,625.000



20 20

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST348

3625

110985

3625

m110980

AN960JD416

NAS1149D0463J Purchased

No

130

Each

6.0000



36 36

Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST357

6

107939

6

m118000

10/6/2010

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 13

Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

AN960JD416L

NAS1149D0416J Purchased

No

130

Each

307.0000

4

4



Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST346	307	
-------	-----	--

110153	307	
--------	-----	--

130	Each	3,067.000
-----	------	-----------



MS21042L3

Purchased

No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	3067	
-------	------	--

114523	567	
--------	-----	--

114718	500	
--------	-----	--

114784	2000	
--------	------	--

130	Each	3,026.000
-----	------	-----------



MS21042L4

Purchased

No

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST300	3026	
-------	------	--

113422	68	
--------	----	--

114523	28	
--------	----	--

114718	930	
--------	-----	--

114784	2000	
--------	------	--

Nut

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
10/07/06	#100	<p><i>Perm. Change</i></p> <p><i>Fit 6 to MS21042t3 should be 13 not 6.</i></p> <p><i>ADD copy of Bm for Ref.</i></p> <p><i>Was correct 10/07/06</i></p>					<i>S 10/07/06</i>

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June 22, 2010 2:33:11 PM

Page 14 /14

Work Order ID: 60000



Parent Item: D205-541-141



Parent Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10

Required Date: 7/05/10

Start Qty: 1.00

Required Qty: 1.00

MS21043-4



Nut

Purchased	No	130	Each	1,360.000	2	2
-----------	----	-----	------	-----------	---	---



<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	40	
104603	40	
ST301	1320	
112492	25	
113069	8	
114348	487	
114523	500	
114784	300	

6

1114348

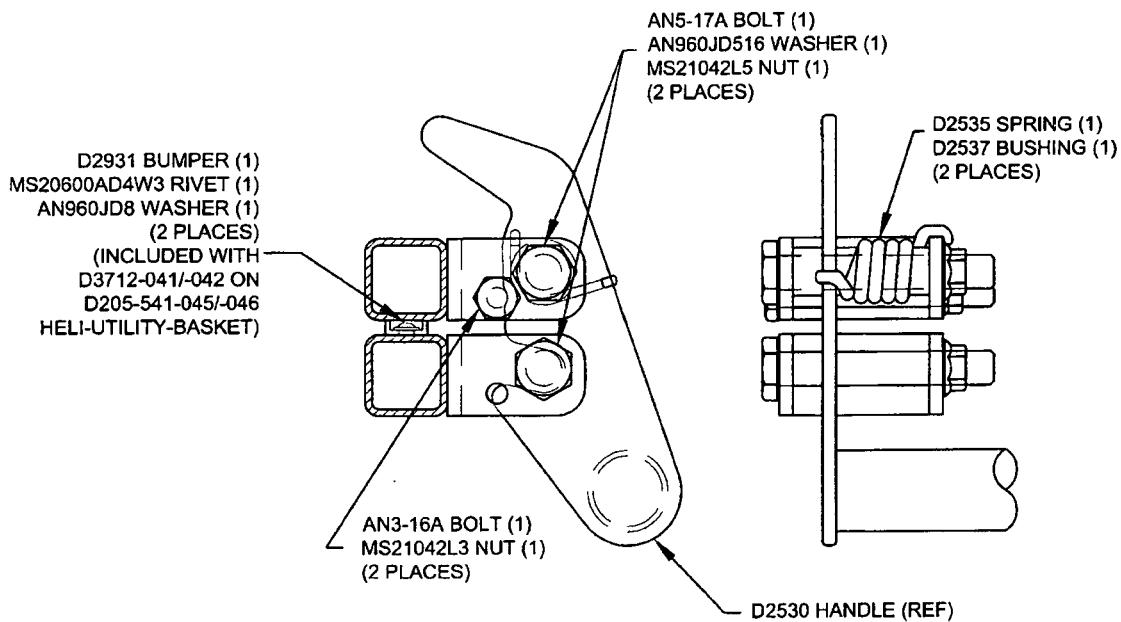


Figure 25-9 – Detail 'H' Handle Assembly

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25-00-00

Revision: 4

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B				Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

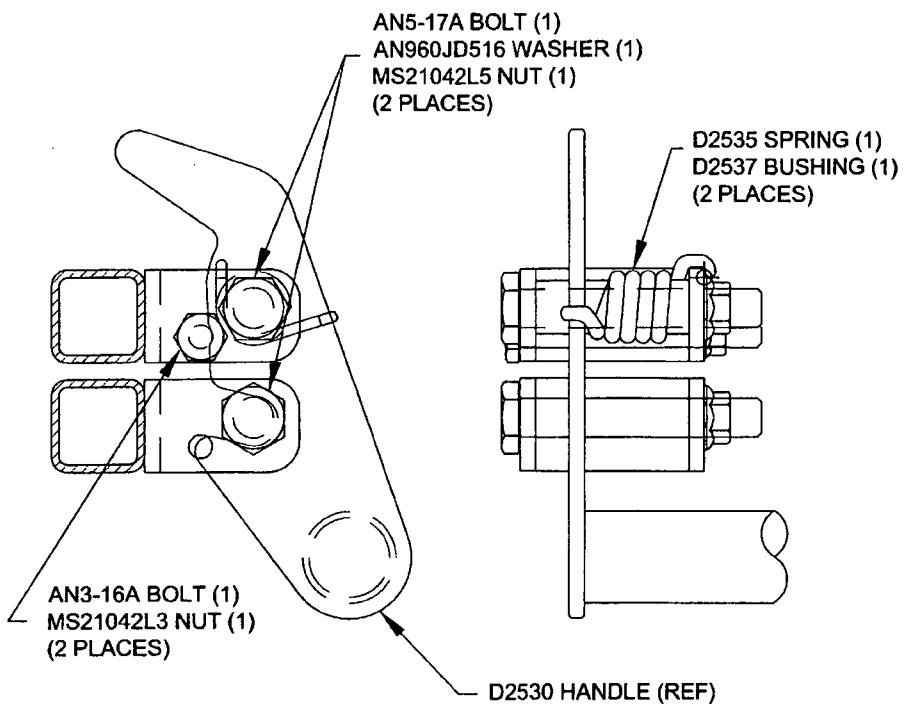
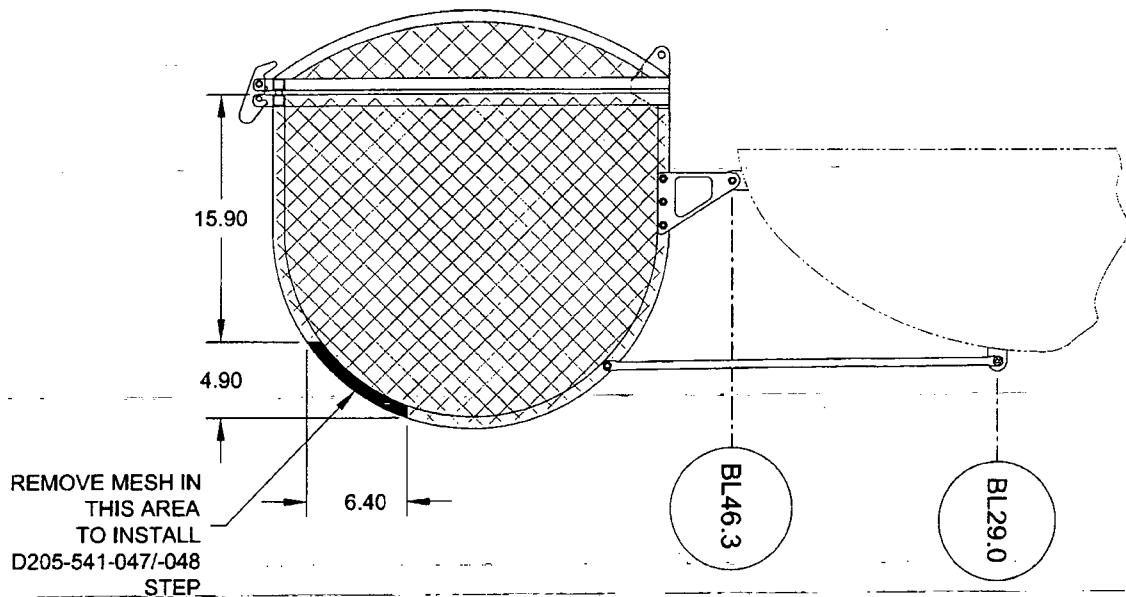


Figure 9 – Detail 'H' Handle Assembly

Figure 10 – Mesh Removal Looking Aft at STA 84.00
(D205-541-044 Shown; D205-541-043 Opposite)

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Date: 10.03.08

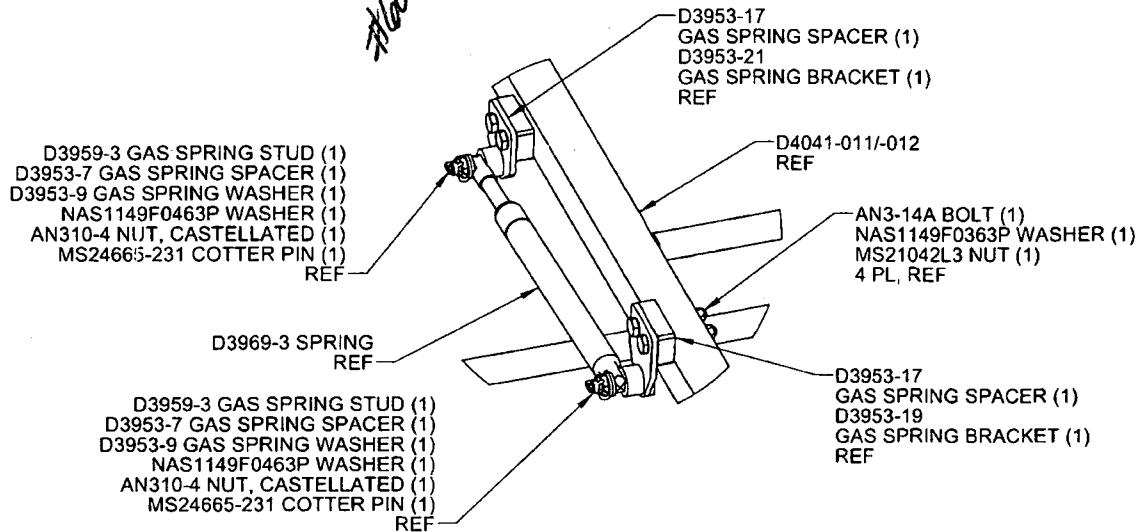
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

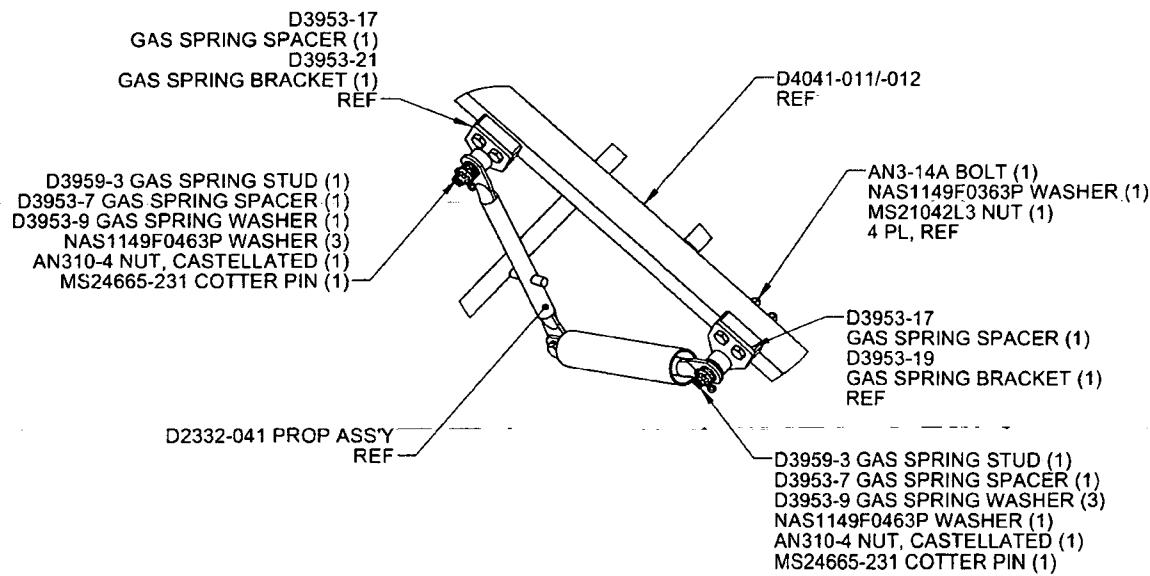
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Figure 20 – Gas Spring Installation at STA 193.0**

(D205-541-141 Shown; D205-541-142 Opposite)

(Mesh not Shown for Clarity)

**Figure 21 – Prop Arm Optional Installation at STA 193.0**

(D205-541-141 Shown; D205-541-142 Opposite)

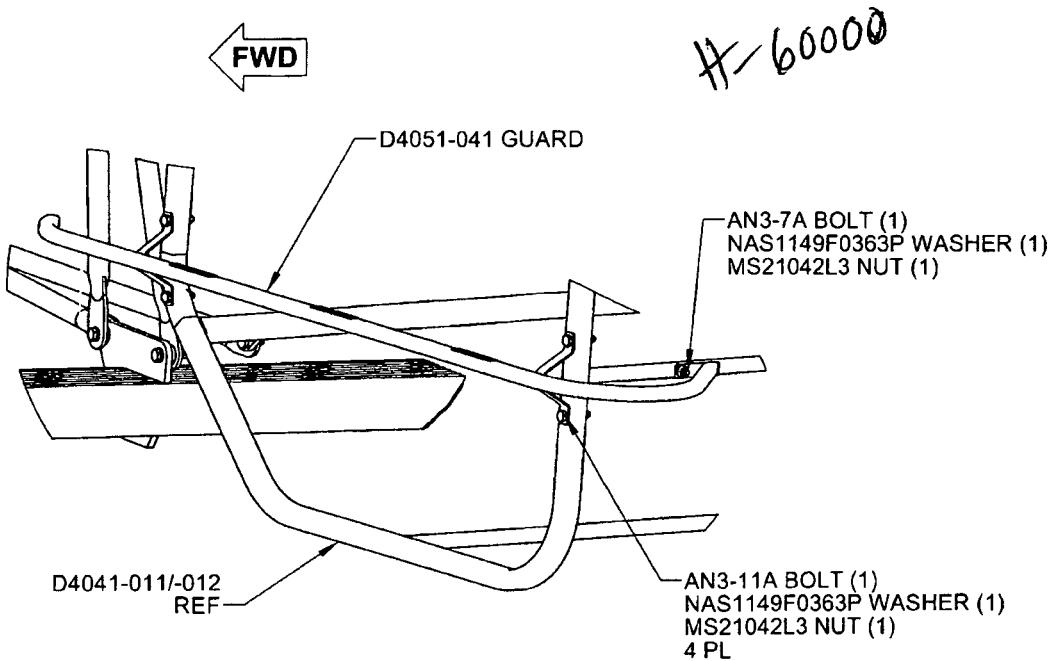
(Mesh not Shown for Clarity)

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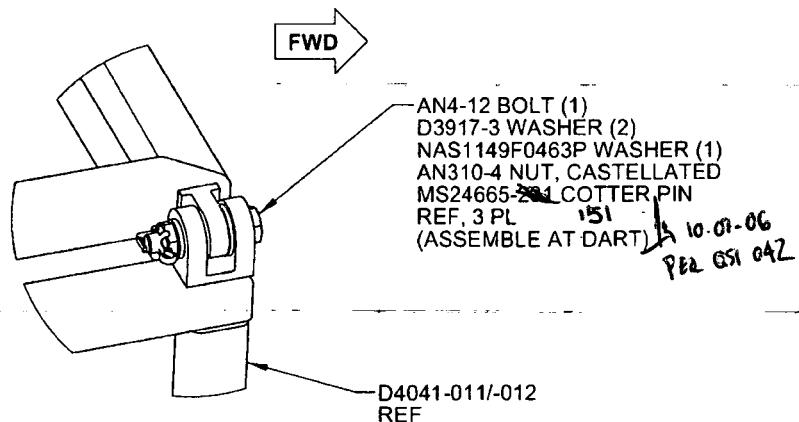
W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No: _____		PAR #: _____		Fault Category: _____	NCR: Yes	No	DQA: _____	Date: _____	
Resolution: _____				Disposition: _____	QA: N/C Closed: _____		Date: _____		
NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector	
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

**Figure 22 –Guard Installation at STA 129.0**

(D205-541-141 Shown; D205-541-142 Opposite)

(Mesh not Shown for Clarity)

**Figure 23 – Hinge Detail**

(D205-541-141 Shown; D205-541-142 Opposite)

(Mesh not Shown for Clarity)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

4.0 WEIGHT AND BALANCE

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
D205-541-043 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	- 63.13 in - 1.60 m	- 7449 in-lb - 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-044 <i>Heli-Utility-Basket™</i>	118 lb 53.6 kg	+ 63.13 in + 1.60 m	+ 7449 in-lb + 85.8 m-kg	132.25 in 3.36 m	15606 in-lb 180.1 m-kg
D205-541-045 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	- 63.13 in - 1.60 m	- 6566 in-lb - 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-046 <i>Heli-Utility-Basket™</i>	104 lb 47.3 kg	+ 63.13 in + 1.60 m	+ 6566 in-lb + 75.7 m-kg	132.25 in 3.36 m	13754 in-lb 158.9 m-kg
D205-541-047 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	- 76.11 in - 1.93 m	- 1066 in-lb - 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-048 <i>Heli-Access-Step™</i>	14 lb 6.4 kg	+ 76.11 in + 1.93 m	+ 1066 in-lb + 12.4 m-kg	126.56 in 3.21 m	+ 1772 in-lb + 20.5 m-kg
D205-541-141 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	- 59.9 in - 1.5 m	- 4133 in-lb - 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg
D205-541-142 <i>Heli-Utility-Basket™</i>	69 lb 31.4 kg	+ 59.9 in + 1.5 m	+ 4133 in-lb + 47.1 m-kg	161.6 in 4.1 m	+ 11150 in-lb + 128.7 m-kg

5.0 PARTS LIST HELI-UTILITY-BASKET™

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
X				1		D205-541-043	HELI-UTILITY-BASKET, LH
	X			1		D205-541-044	HELI-UTILITY-BASKET, RH
		X		1		D205-541-045	HELI-UTILITY-BASKET, LH
			X	1		D205-541-046	HELI-UTILITY-BASKET, RH
				1X1		D205-541-141	HELI-UTILITY-BASKET, LH
				1	X	D205-541-142	HELI-UTILITY-BASKET, RH
				1	1	DSI 9302-011	STRUT MODIFICATION KIT (FOR D205-633 STEP INSTALLATION)
2*	2*					D2022-101	SPACER
				2	2	D2022-101	SPACER (FOR D205-633 STEP INSTALLATION)
1	1	1	1			D2199-1	STRUT
1	1	1	1			D2199-23	STRUT
1	1	1	1			D2199-25	STRUT
1*	1*	1*	1*			D2258-300	LABEL
1*	1*	1*	1*			D2332-041	PROP ASSEMBLY
				1	1	D2332-041	PROP ASSEMBLY (OPTIONAL)
				1	1	D2464-0410	NEOPRENE SEAL
1	1	1	1			D2498	MOUNTING LUG
1	1	1	1			D2499	MOUNTING LUG
1*	1*			1		D2512	BASKET LID ASSEMBLY

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Revision: J
Date: 10.03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

• NOTE: Date & initial all entries

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
2	2	2	2			D2515	BUSHING
1*	1*	1*	1*			D2530	HANDLE ASSEMBLY
2*	2*	2*	2*			D2535	SPRING
2*	2*	2*	2*			D2537	BUSHING
2*	2*					D2931	BUMPER
1	1	1	1			D3052-1	MOUNTING LUG
1*						D3053-041	BASKET BASE ASSEMBLY, LH
	1*					D3053-042	BASKET BASE ASSEMBLY, RH
		1*				D3712-041	BASKET BASE
			1*			D3712-042	BASKET BASE
		1*				D3713-041	LID ASSEMBLY
			1*			D3713-042	LID ASSEMBLY
	6*	6*				D3723-1	BUSHING
			1	2	2	D3953-9	GAS SPRING SPACER (OPTIONAL)
				1		D4041-011	SHORT BASKET ASS'Y, LH
					1	D4041-012	SHORT BASKET ASS'Y, RH
				1		D4048-041	MOUNTING LUG ASS'Y
					1	D4048-042	MOUNTING LUG ASS'Y
				1		D4048-5	MOUNTING LUG
					1	D4048-6	MOUNTING LUG
				1		D4048-7	MOUNTING LUG
					1	D4048-8	MOUNTING LUG
				6	6	D4048-9	BUSHING
				1		D4049-041	MOUNTING LUG ASS'Y
					1	D4049-042	MOUNTING LUG ASS'Y
				1		D4049-5	MOUNTING LUG
					1	D4049-8	MOUNTING LUG
				1	1	D4050-1	STRUT
					1	D4050-3	STRUT
				1		D4050-5	STRUT
					1	D4050-8	STRUT
				1		D4051-041	GUARD (OPTIONAL)
					1	D4051-042	GUARD (OPTIONAL)
	2*	2*	2*	2*		D4052-1	EYE BOLT
					10	10	AN3-5A
					1	1	AN3-7A
					4	4	AN3-11A
2*	2*	2*	2*			AN3-16A	BOLT
					5	5	AN4-6A
2*	2*					AN4-7A	BOLT
2	2	2	2	1	1	AN4-7A	BOLT
3	3	3	3	2	2	AN4-12A	BOLT
9	9	9	9			AN4-13A	BOLT
2	2	2	2	11	11	AN4-14A	BOLT
				1	1	AN4-16A	BOLT
		3*	3*			AN4-20A	BOLT

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Revision: J
Date: 10.03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

Qty -043	Qty -044	Qty -045	Qty -046	Qty -141	Qty -142	Part Number	Description
1*	1*	1*	1*	1		AN4-22A	BOLT
1*	1*	1*	1*	1		AN4-24A	BOLT
1	1	1	1			AN5-7A	BOLT
1	1	1	1			AN5-13A	BOLT
4*	4*	4*	4*			AN5-17A	BOLT
				5	5	AN960-10	WASHER (OR NAS1149F0363P) (OPTIONAL)
				20	20	AN960JD10L	WASHER (OR NAS1149D0332J)
2*	2*	6*	6*			AN960JD416	WASHER (OR NAS1149D0463J)
				2	2	AN960-416	WASHER (OR NAS1149F0463P) (OPTIONAL)
27	27	27	27	36	36	AN960JD416	WASHER (OR NAS1149D0463J)
2*	2*	2*	2*	4	4	AN960JD416L	WASHER (OR NAS1149D0416J)
4*	4*	4*	4*			AN960JD516	WASHER (OR NAS1149D0563J)
3	3	3	3			AN960JD516	WASHER (OR NAS1149D0563J)
2	2					AN960JD8	WASHER (OR NAS1149DN832J)
4*	4*	4*	4*			AN970-4	WASHER
2*	2*					MS20600AD4W3	RIVET
2*	2*	2*	2*	8	8	MS21042L3	NUT (OR MS21042-3)
				5	5	MS21042L3	NUT (OR MS21042-3) (OPTIONAL)
4*	4*	5*	5*			MS21042L4	NUT (OR MS21042-4)
16	16	16	16	20	20	MS21042L4	NUT (OR MS21042-4)
				2	2	MS21043L4	NUT (OR MS21043-4)
4*	4*	4*	4*			MS21042L5	NUT (OR MS21042-5)
2	2	2	2			MS21042L5	NUT (OR MS21042-5)

* = ASSEMBLED AT DART

6.0 PARTS LIST HELI-ACCESS-STEP™

Qty -047	Qty -048	Part Number	Description
X		D205-541-047	HELI-ACCESS-STEP, LH
	X	D205-541-048	HELI-ACCESS-STEP, RH
1		D3724-041	STEP ASSY, LH
	1	D3724-042	STEP ASSY, RH
2	2	D3731-1	PLATE
2	2	D3751-1	SHIM
6	6	AN4-13A	BOLT
6	6	AN4-14A	BOLT
24	24	AN960JD416	WASHER
12	12	MS21042L4	NUT (OR MS21042-4)

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Revision: J
Date: 10.03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Ship July 6th or sooner

Work Order ID 60000

June 22, 2010 2:33:17 PM



Page 1

Item ID: D205-541-141

Accept



Setup Start



Stop



Revision ID:

Item Name: Heli-Utility-Basket, LH

Start Date: 6/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 7/05/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: *W*

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D205-541

J

D4041

A

100

0.00



DOCUMENT CONTROL

DC

0.00

Document Control

Memo

Photocopy bluefile & type labels per PPPD205-541-141

CHG001

100-6-23
J

110



Small Fab

0.00

Small Fab

Memo

0.00

Small Fab

Assemble basket as per Dwg.

REFERENCE ONLY